

Work Order ID 67948

Tuesday, April 05, 2011 7:44:24 AM



Page 1

Item ID: D3188-6

Accept



Setup Start



Revision ID:

Item Name: Spacepod Body

Stop



Start Date: 4/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 11/04/05

Tooling:

Date:

Run Start



QC: _____

Date: _____

SPC (Y/N):

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3188	Rev F

100 QC6- Inspect dimensions to drawing 0.00



QC

Quality Control

Memo

0.00

Check for void spot and pins.

M 11-08-25 (1)

BR 11-08-25

110



Identify as per dwg & Stock Location: Composite 0.00

0.00

85 11-08-25

Packaging

Packaging

Memo

0.00

120



QC21- Final Inspection - Work Order Release 0.00

0.00

QC

Quality Control

Memo

0.00

N/K 11-08-25

CL 11/08/25

Picklist Print

Page 1

Tuesday, April 05, 2011 7:44:21 AM

Work Order ID: 67948



Parent Item: D3188-6



Parent Item Name: Spacepod Body

Start Date: 4/5/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 09-02-05 New Issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3188-2M 		Manufactured	No		100		Each	2.0000	1	1		BT 11-08-25	

SPACEPOD BODY RH

Location	Loc Qty	Loc Code
CA	2	
46180A	1	
66597	1	

8 7 6 5 4 3 2 1

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GENERAL NOTES:

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
 12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
 18 oz ROVING "E" GLASS (18 oz CLOTH)
 OWENS CORNING MILLED FIBERS, "E" GLASS
 3M K20 GLASS BUBBLES

FOAM: A600 CORE CELL
 OR DIVINYCELL
 OR AIREX
 OR KLEGECCELL
 FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

1. MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

- 2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.
 APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3188-1 = N/A
 D3188-2 = N/A
 D3188-3 = N/A
 D3188-5 = N/A
 D3188-6 = N/A
 D3188-7 = N/A
- 8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

CD1104105

W10:67948

RELEASED
 2009-10-20
M

F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL/ FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D6000-XXX LABELS	LE	06.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	CB	06.10.06
A	NEW ISSUE	CP	03.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[initials]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[initials]</i>	D3188	SHEET 1 OF 11
APPROVED	<i>[initials]</i>	TITLE	SCALE
DE APPR.	<i>[initials]</i>	SPACEPOD BODY	NTS
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

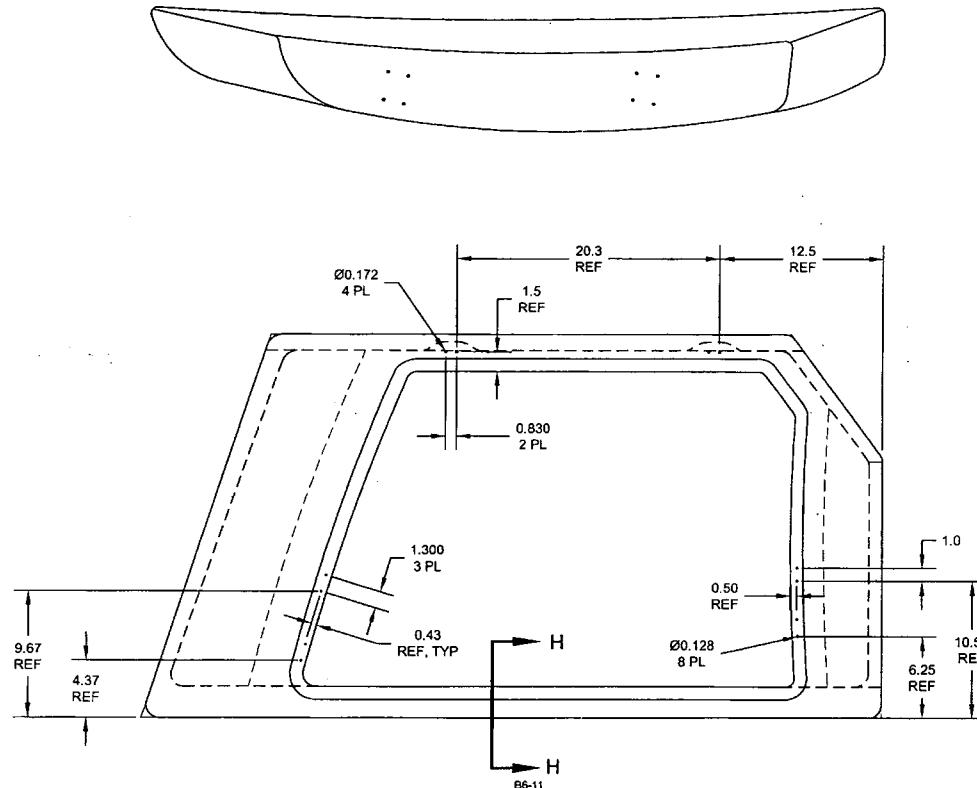
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D3188-1 SPACEPOD BODY
MAKE FROM D3188-1M

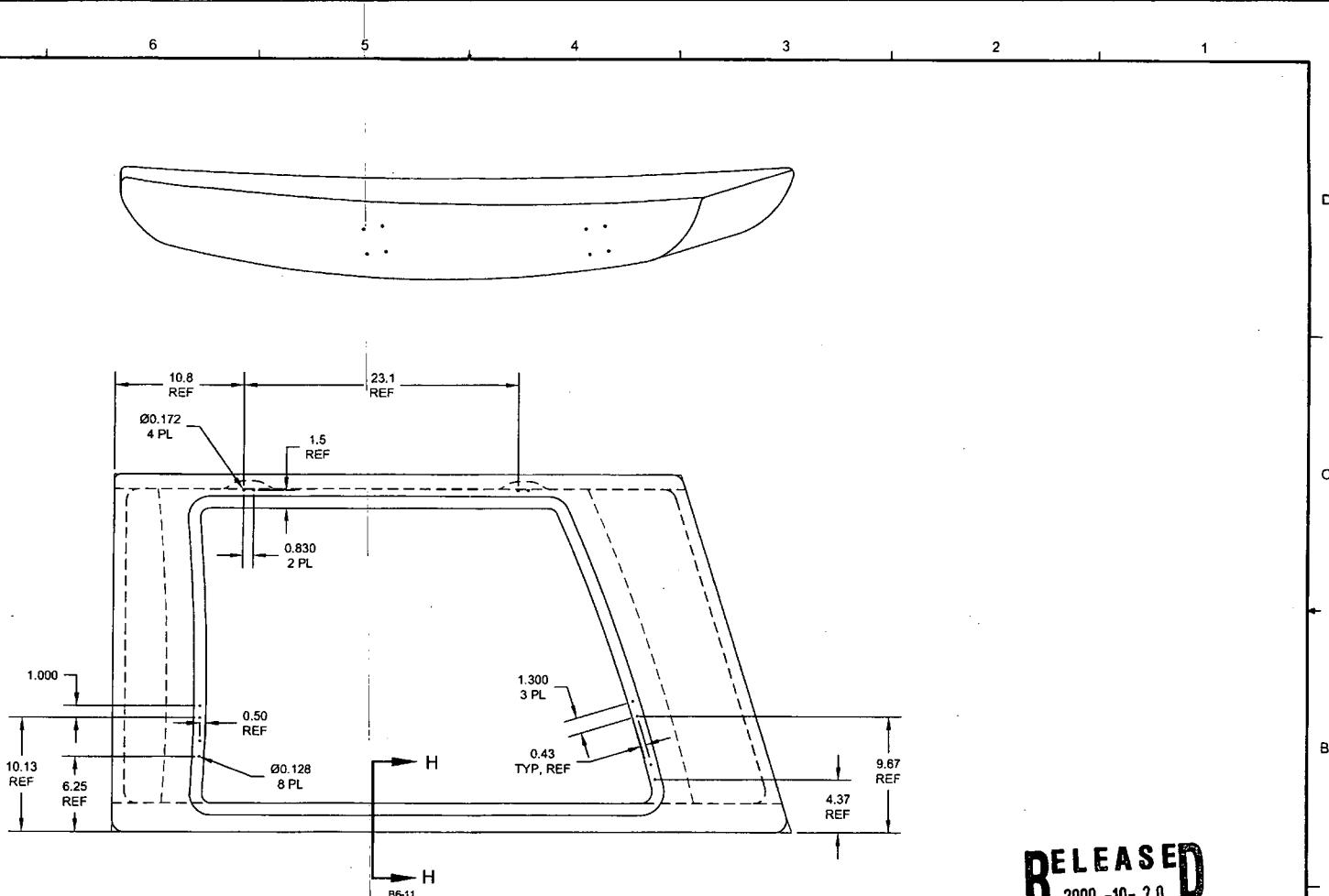
- NOTES:
 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-1 DOOR DURING ASSEMBLY
 2) SEE SHEET #11 FOR SECTION VIEW

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MFG. APPR.	<i>M</i>	REV. F
APPROVED	<i>M</i>	D3188
DE APPR.	<i>M</i>	SHEET 2 OF 11
DATE	09.07.13	TITLE
		SPACEPOD BODY
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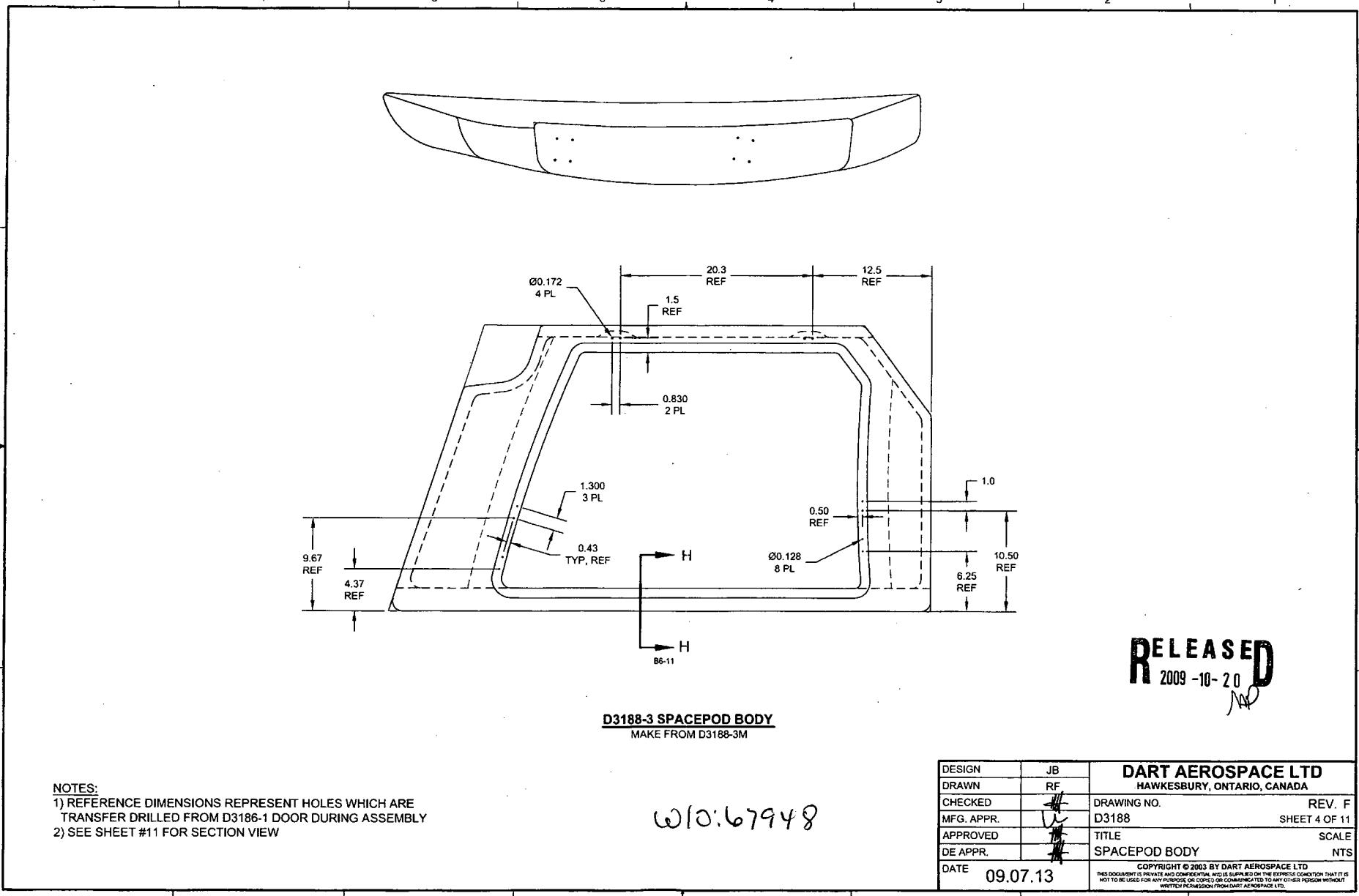
D3188-2 SPACEPOD BODY
MAKE FROM D3188-2M

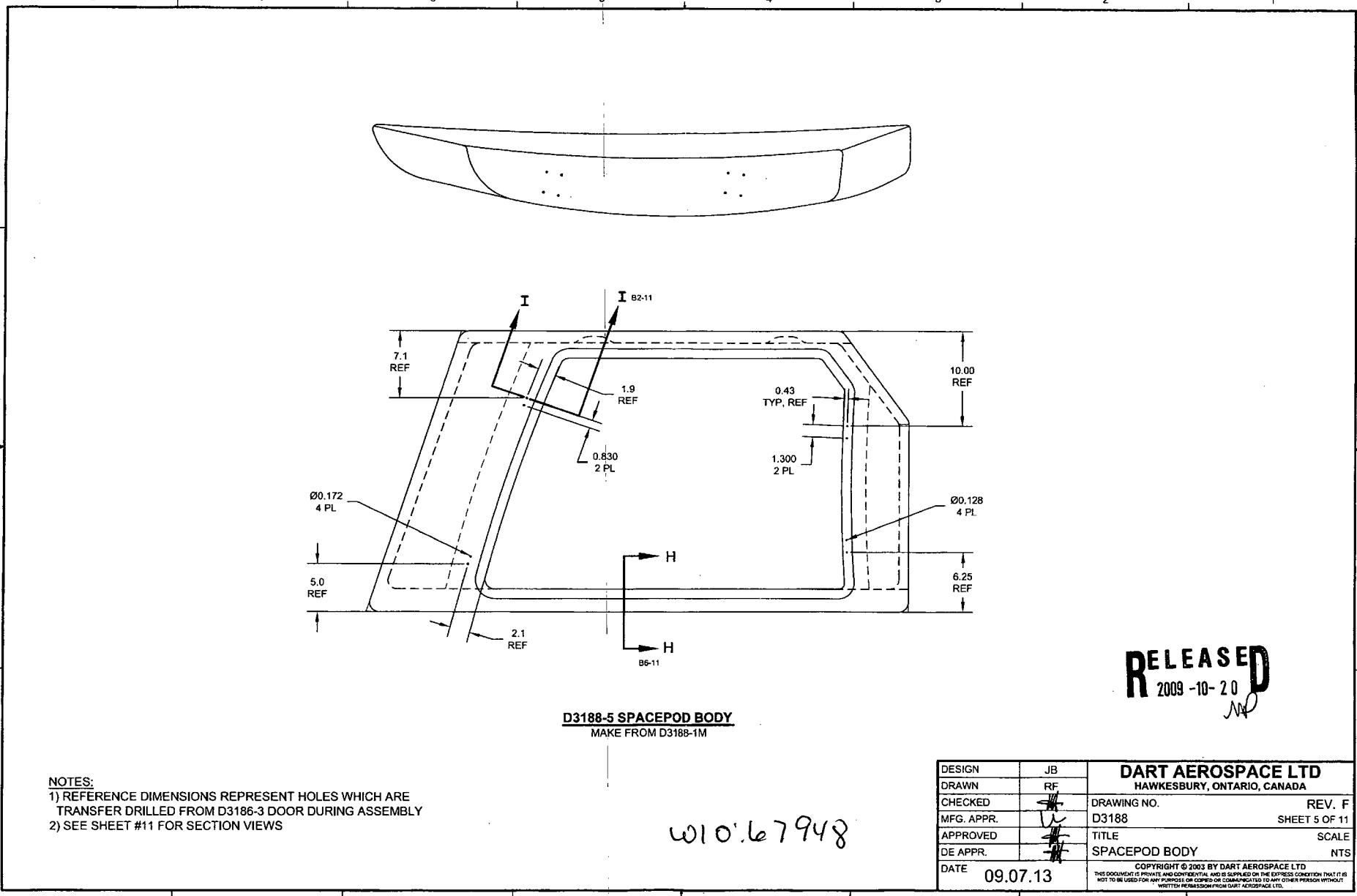
NOTES:
 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
 TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
 2) SEE SHEET #11 FOR SECTION VIEW

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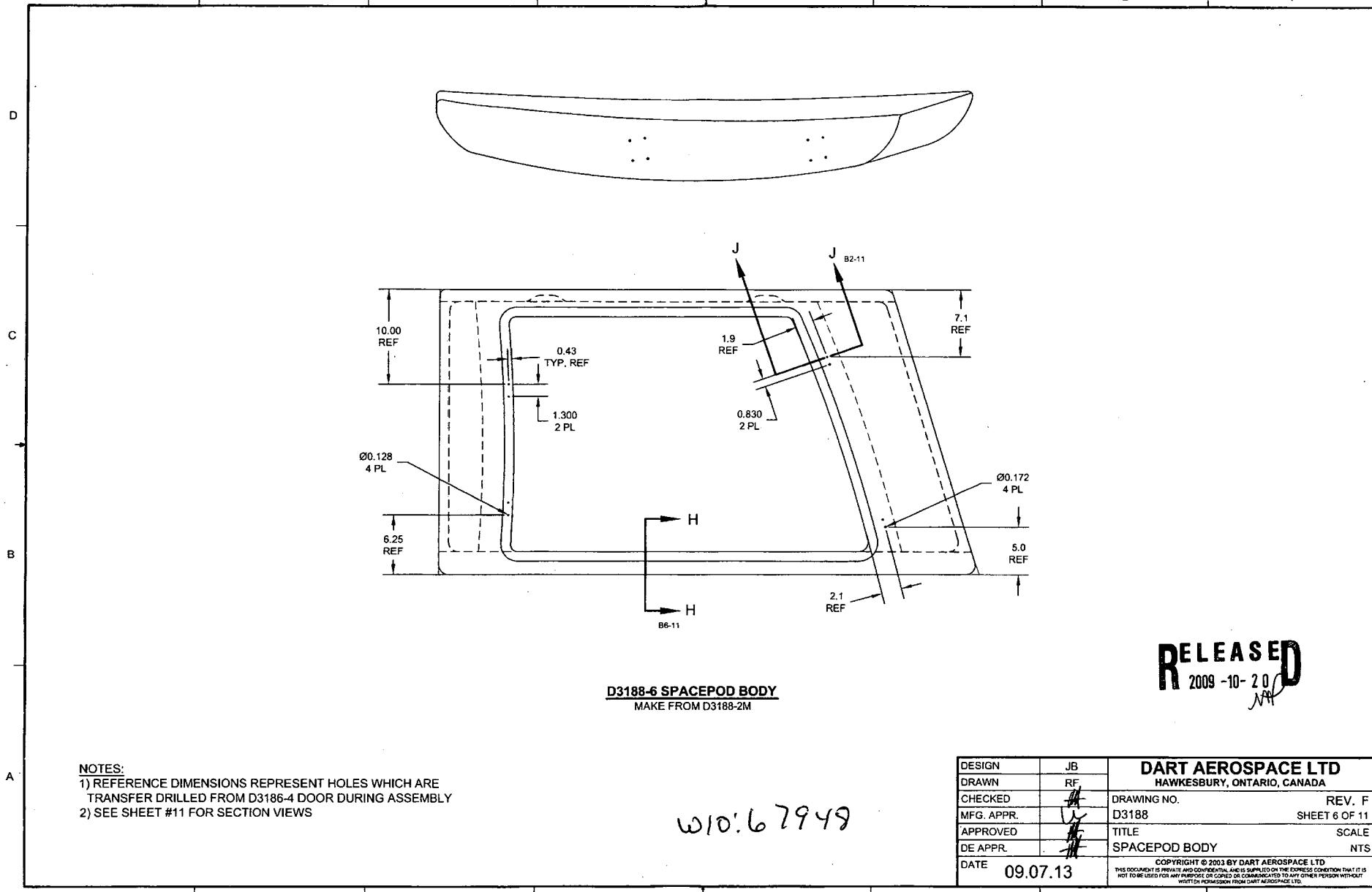
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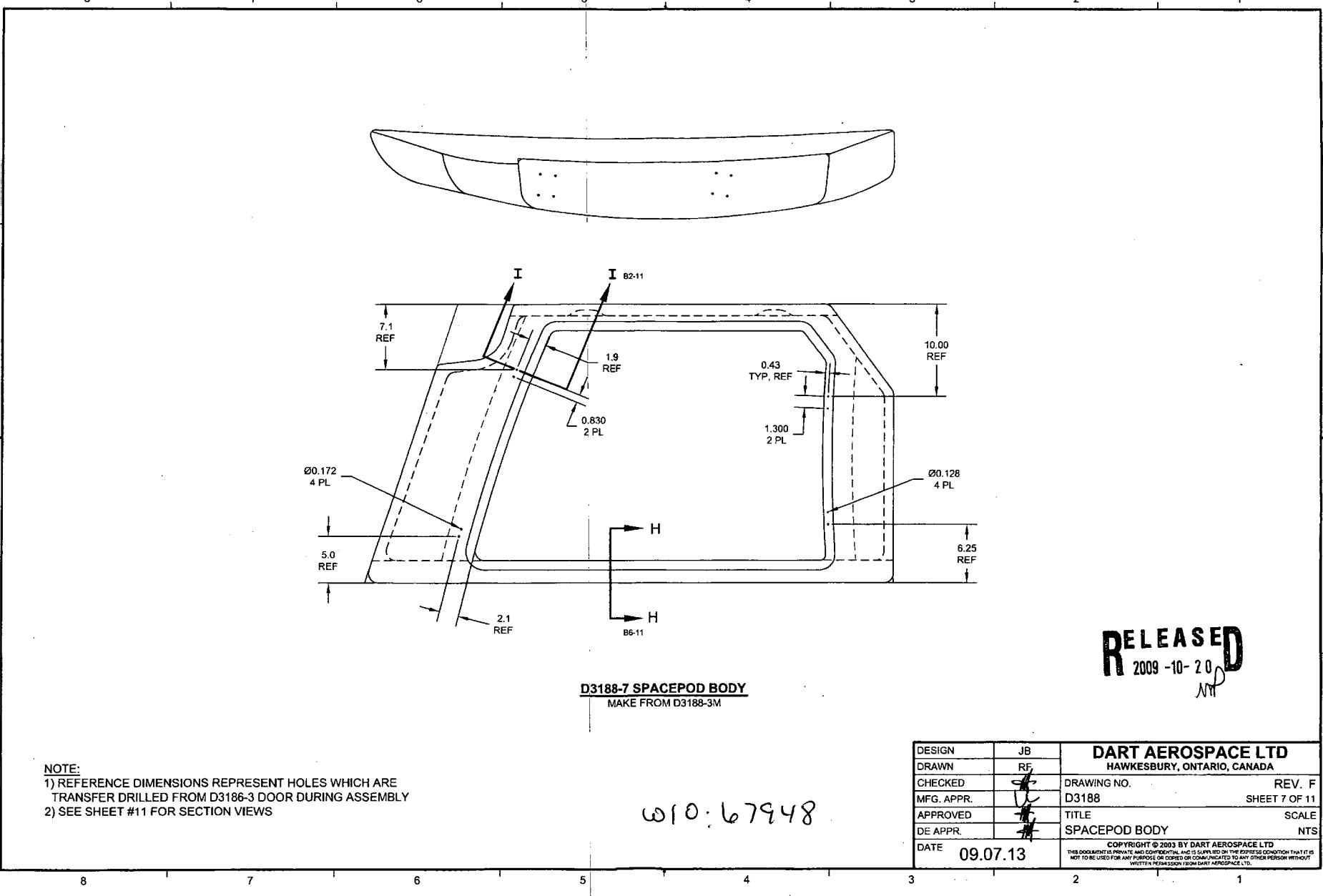
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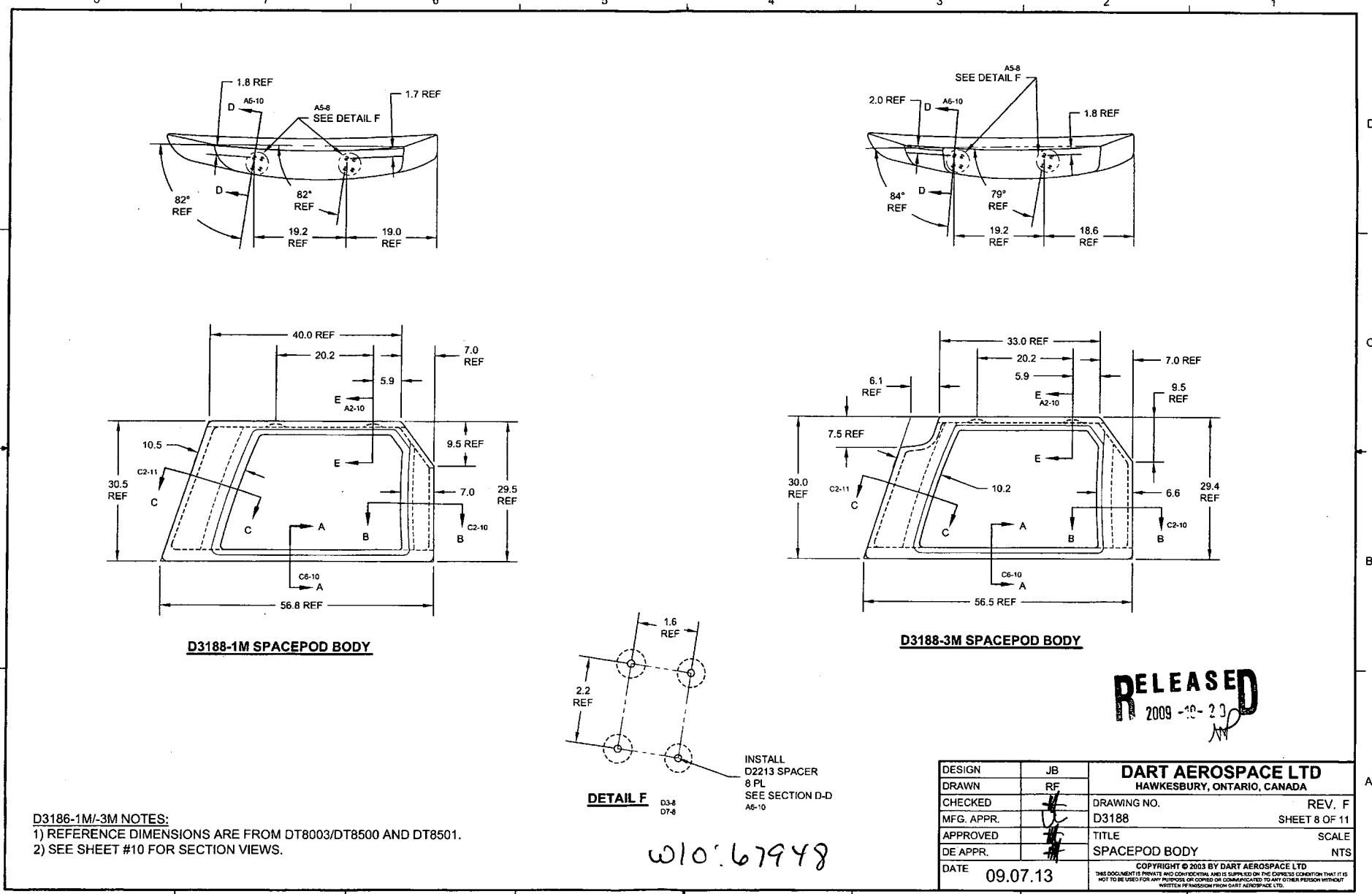
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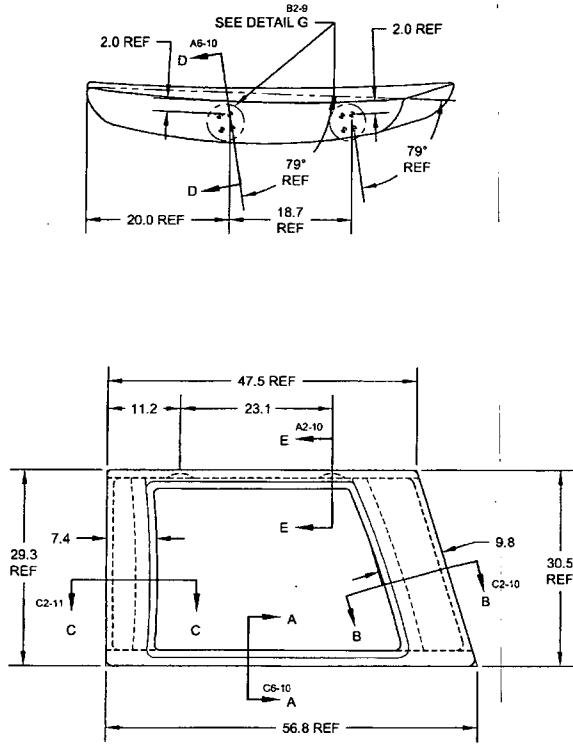
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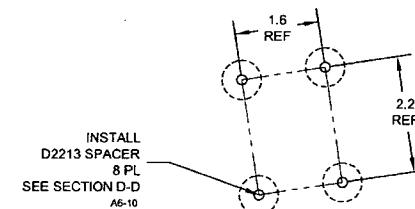


D3188-2M SPACEPOD BODY

D3186-2M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
2) SEE SHEET #10 FOR SECTION VIEWS.**

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DETAIL G

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